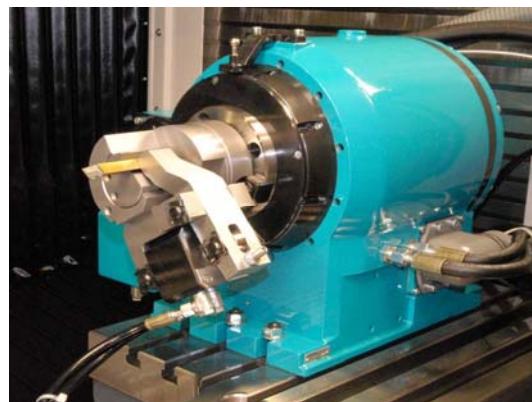


## Gear Blade Pentac 6"

A12-310

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade.



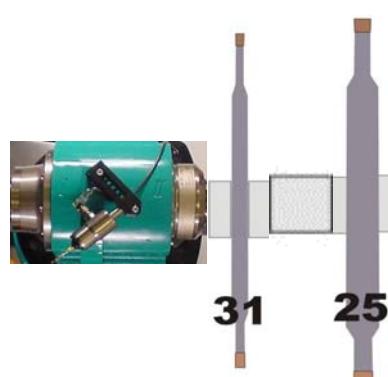
### 1. Cycletime for Production

| Tool specifications<br>inner blade and outer blade 6" |   |   |   |   |   |
|---|---|---|---|---|---|
| Material HSS  | Probe   | Prs.Side rough  | Clr.Side rough  | Prs.Side fin.   | Clr.Side fin.   |
| Operations  |  |    |    |    |    |
| Feed [mm/Min]   | 2000  | 40  | 40  | 80  | 80  |
| Power [kW]  |   | 1   | 1   | 1   | 1   |
| Cutting feed [m/s]                                    |   | 32  | 32  | 32  | 32  |
| Used wheels   |   |  |  |  |  |
| Grinding time [s]                                     | 18  | 109   | 109   | 22  | 22  |
| Total cycle time                                      | 4 Min 41  |   |   |   |   |

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

25 Ø250 1A1 B126  
31 Ø250 14A1 B126



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5

responsible engineer: OP, 23.4.09

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY  
FOR TOOLING